



006527

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RBW6505G00231-3T**Job Sheet 186609****Part No:** RBW6505G00231-3T**Job Qty:** 1 ea**Part Name:** AW139 Tail Rotor Gear Box Seal Replacement Tool**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/19/18**Job Tracking No:****Due Date:** 11/23/18**Created By:** Linda Lacelle**Type:** SOLD**Description:****Note:** DWG RBW6505G00231-3T Rev 3 IPP Rev A 18.02.07 New issue DP verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/23/18	0.00	0.00	Start Up Small Fab-4		MLC DAS
110	Small Fab	1 pcs		11/23/18	0.00	1.00	Small Fab-4		MLC 858
120	QC	1 pcs		11/23/18	0.00	0.00	QC4		399-89
130	Packaging	1 pcs		11/23/18	0.00	0.00	Packaging3-1		MLC
140	QC21-FG	1 Ea		11/23/18	0.00	0.00	QC21		DEC 31 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-IM2700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6505G00231-3T-15 to RBW6505G00231-3T-13 foam as per DWG. 6-Glue foam to case and pack case as per
DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5089129
APP-IM2700-E	Case	1 Ea (1 ea)	110-Small Fab	5124752
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	3021040
RBW6500X01611-W142H-3T	Tail Rotor Gear Box Output Oil Seal Removal & Press Tool	1 Ea (1 ea)	110-Small Fab	5170550
RBW6505G00231-3T-11	Bottom Tool Cushion use in case APP-IM2700-E	1 Ea (1 ea)	110-Small Fab	5124753
RBW6505G00231-3T-13	Top Tool Cushion use in case APP-IM2700-E	1 Ea (1 ea)	110-Small Fab	5124754
RBW6505G00231-3T-15	Inside Placard	1 Ea (1 ea)	110-Small Fab	5121960
RBW6522A00231-W142AJ-3T	Tail Rotor Gear Box/Servo Actuator Oil Seal Fit/Extracting Tool	1 Ea (1 ea)	110-Small Fab	5140703
RBW6522A00231-W142AK-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool	1 Ea (1 ea)	110-Small Fab	5061472
RBW6522A00231-W142S-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool	1 Ea (1 ea)	110-Small Fab	5061202

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	691	0
110-Small Fab	APP-IM2700-E	1	4	0
	RB41011	1	702	0
	RBW6500X01611-W142H-3T	1	1	0
	RBW6505G00231-3T-11	1	2	0
	RBW6505G00231-3T-13	1	2	0
	RBW6505G00231-3T-15	1	2	0
	RBW6522A00231-W142AJ-3T	1	1	0
	RBW6522A00231-W142AK-3T	1	4	0
	RBW6522A00231-W142S-3T	1	4	0
Part Specifications				
Specifications could not be found.				

Plex 11/19/18 9:55 AM dart.lacelle.linda



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Container No: S128947



Part: RBW6505G00231-3T

Job No: 186609

Serial No/Batch: S128947

Revision: 3

Inspector:

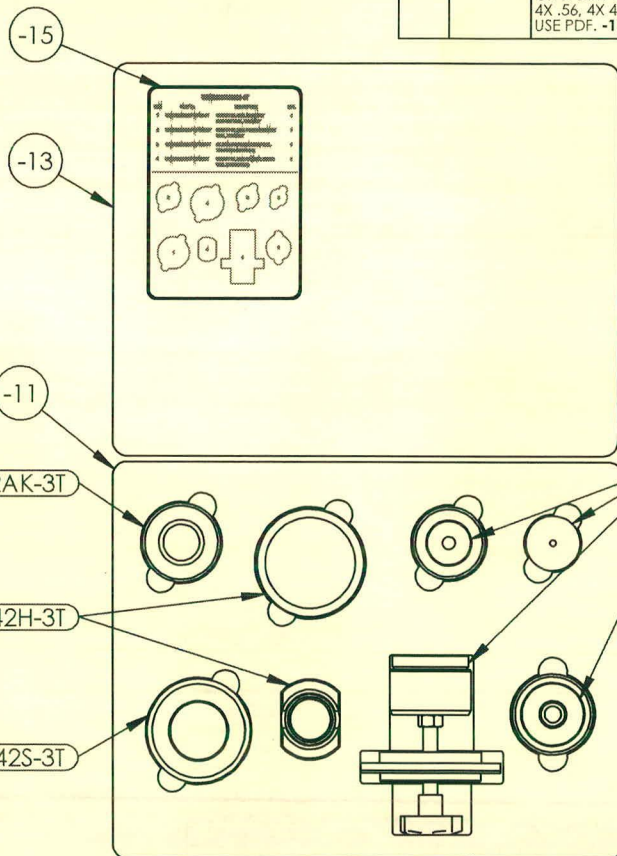
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Instructions:

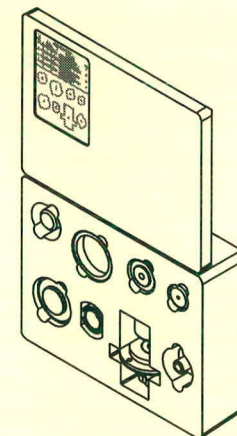
Date: 11/19/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-11 CH'D DEPTH WAS 3-1/2 IS 4-3/4, WAS 4-3/4 IS 5-9/16. -13 CH'D PLACARD LOCATION CUTOUT WAS HITTING TOOL WITH LID CLOSED.	10/2/2012	RJC	SE
2	15-0145	-11 ADDED MISSING DIM 8X R.13. -13 CH'D DIM WAS .07 IS .13. -15 REPLCED CONTENTS LIST WITH RBW6505G00231-3T, DELETED LINES FROM TOOL LAYOUT, ADDED ITEM NUMBERS TO TOOL LAYOUT. ADDED -19 AND -21.	6/23/2015	RJC	JAG
3	16-0254	-11, -13, -15 CH'D DWG. TO SHEET METAL TOLERANCE. -11, -13 CH'D MATERIAL AND VENDOR WAS Y20 BLACK I.R. SPECIALTY FOAM IS ETHAFOAM 220, BLACK (CASE SOLUTIONS). -11 CH'D DIM WAS 17.00 IS 17.15, WAS 22.00 IS 22.15, WAS 6.00 IS 6.08, WAS 4X 4° IS 4X 2°, ADDED DIM 4X .65, 4X 45°. -13 CH'D DIM WAS 17.00 IS 16.96, WAS 22.00 IS 21.95, WAS 1.88 IS 1.83, WAS 4X 4° IS 4X 2°, ADDED DIM 4X .56, 4X 45°. -15 DELETED ALL TEXT HT. NOTES, CH'D NOTE WAS USE PDF FOR MANUFACTURING IS USE PDF. -19, -21 DELETED FROM BOM. DELETED -17 P/N FOR DART PLACARD.	12/5/2016	RJC	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 172013



TOOL & KIT No. REFERENCE

DART KIT No.	DART TOOL No.	ORIGINAL No.
RBW6505G00231-3T	=	3T6505G00231
RBW6505G00231-3T-1	= RBW6522G00231-W142S-3T	= 3T6522G00231-W142S
RBW6505G00231-3T-3	= RBW6522G00231-W142AK-3T	= 3T6522G00231-W142AK
RBW6505G00231-3T-5	= RBW6522G00231-W142AJ-3T	= 3T6522G00231-W142AJ
RBW6505G00231-3T-7	= RBW6500X01611-W142H-3T	= 3T6500X01611-W142H

DART AEROSPACE											
TITLE TGB SEAL REPLACEMENT TOOL KIT											
DWG NO. RBW6505G00231-3T	REV 3										
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125/
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<table border="1"> <tr> <td>DRAWN BY:</td> <td>PERRITT</td> </tr> <tr> <td>CHECKED:</td> <td>DUERFELDT</td> </tr> <tr> <td>OPPS APPR:</td> <td>ANDERSON</td> </tr> <tr> <td>QA APPR:</td> <td>LINDSAY</td> </tr> <tr> <td>APPROVED:</td> <td>GILBERT</td> </tr> </table>		DRAWN BY:	PERRITT	CHECKED:	DUERFELDT	OPPS APPR:	ANDERSON	QA APPR:	LINDSAY	APPROVED:	GILBERT
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APPROVED:	GILBERT										
SCALE 1:8	DATE 1/3/2009										
SHEET 1 OF 4											

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	TGB/MAST OUTPUT OIL SEAL ASSEMBLY SUPPORT TOOL		RBW6522A00231-W142S-3T	1
				1	OUTPUT OIL SEAL PRESS TOOL		RBW6522A00231-W142AK-3T	1
				1	TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL		RBW6522A00231-W142AJ-3T	1
				1	TGB OUTPUT OIL SEAL REMOVAL AND PRESS TOOL		RBW6500X01611-W142H-3T	1
		B/O	-9	1	CASE	BLACK PLASTIC	PELICAN #APP-IM2700-E	N/S
		B/O	-11	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	6.08 X 17.15 X 22.15 (CASE SOLUTIONS)	2
		B/O	-13	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	1.83 X 16.96 X 21.95 (CASE SOLUTIONS)	3
			-15	1	INSIDE PLACARD	PLASTIC		4
		B/O		1	DART PLACARD	ALUMINUM	#RB41011	N/S

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	Pressure/Forced	☐	Temperature/Cure
Design	☐	Operator	Bending	☐	Set-up
Doc/Data	☐	Offset/Setup	Centre Not Concentric	☐	BOM/Route
Equip/Tooling	☐	Supplier	Cracks	☐	Broken/Damage/Defect
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
Material	☐	Use for Testing	Cuffs	☐	Contamination
Internal Transport	☐	Poor Information	Crushing	☐	Countersink
Tribal Knowledge	☐	Rushing	Heat Treat	☐	Cut Too Short
LOA	☐	Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
Substation	☐	Process Improvement	Marks/Chatter	☐	Drill Holes
Past Expiry Date	☐	Manufacturing Process	OTHER :		
Misidentified	☐	Past Due			